

Date: Tuesday, 8/14/2007 10:56:40 AM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RIGHT ARM WELDMENT
Job Number : 33890	
Estimate Number : 12104	
P.O. Number : <i>NA</i>	Part Number : D3354043
This Issue : 8/14/2007 S.O. No. : <i>NA</i>	Drawing Number : D3354 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 8/14/2007 Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 31283	Material : <i>NA</i>
Written By : <i>PL 07-08-14</i>	Due Date : 8/21/2007 Qty: 1 Um: Each
Checked & Approved By : _____	
Comment : est rev A 06.01.25 new issue EC	
est rev B 07.05.14 rev B dwg Ec	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description

1.0 D33543 shaft



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	part number	description	batch
1	D3354-3	shaft	✓ 830399

PL 07-08-14

①

2.0 D33545 right arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

pick:

qty	part number	description	batch
1	D3354-5	right arm	✓ 330400

PL 07-08-14

①

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Weld assembly as per dwg D3354

2-Grind welds flush as per dwg D3354

PL 07-08-14

①

4.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10/07/08/14 (1)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIGHT ARM WELDMENT

Job Number: 33890

Part Number: D3354043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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5.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

11/07/08/14 ①

6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

1-Mask areas indicated on dwg D3354

2-Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

9.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

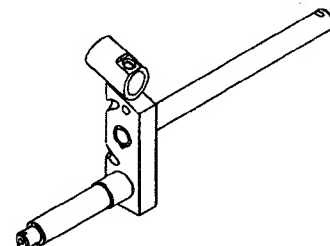
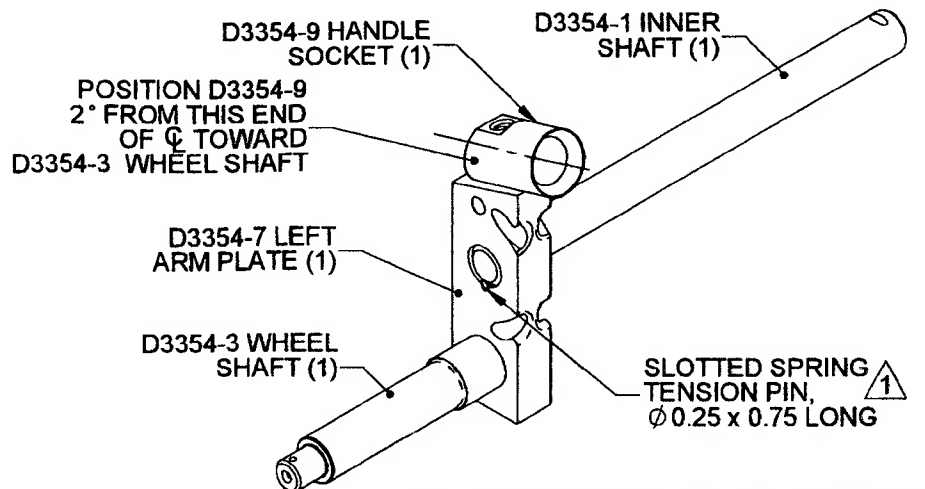


h 6712-05



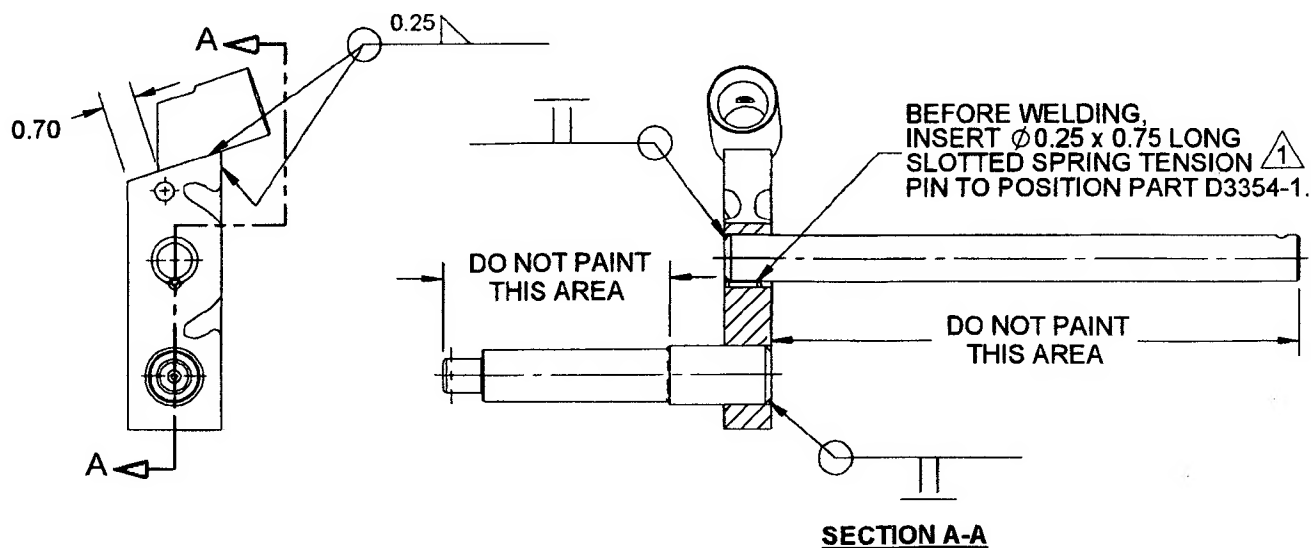
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. LEFT ARM WELDMENT	REV. B SHEET 1 OF 7
DATE 07.02.02	TITLE D3354	SCALE 1:4	
REV	DATE	DESCRIPTION	
A	04.12.13	NEW ISSUE	
B	07.02.02	REVISED DIMENSIONS	

RELEASED
07.02.02



**D3354-042 MIRROR
ARM WELDMENT**

D3354-041 LEFT ARM WELDMENT



NOTES:

- 1) POSSIBLE SUPPLIER: SPAENAU, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

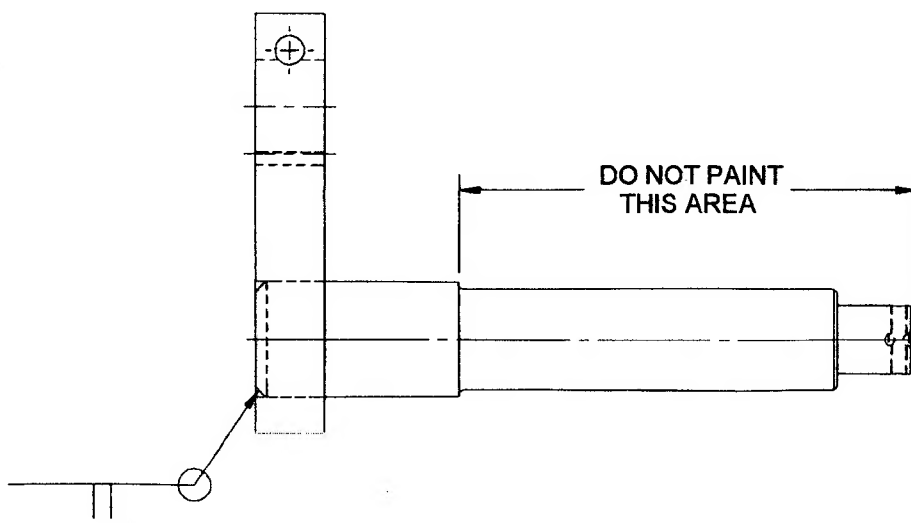
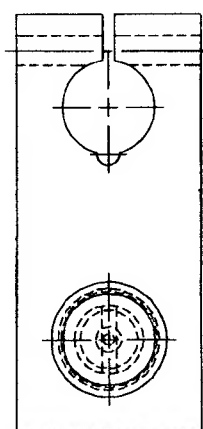
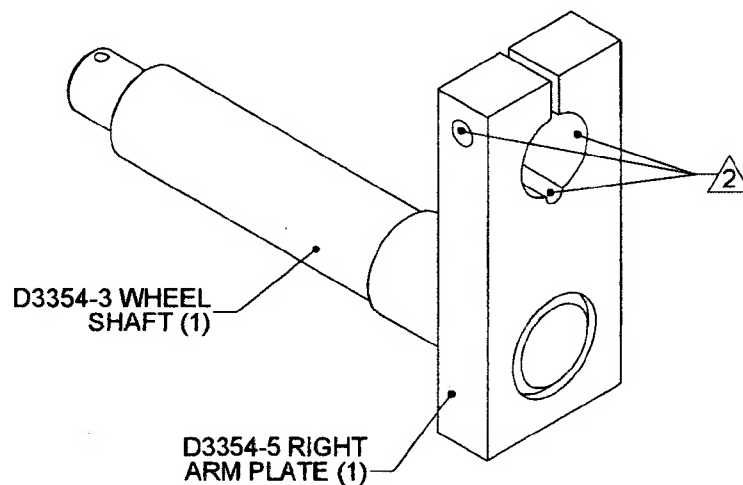
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DATE 07.02.02	TITLE LEFT ARM WELDMENT		SCALE 1:2

RELEASED
07.02.02



D3354-043 RIGHT ARM WELDMENT

NOTES:

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

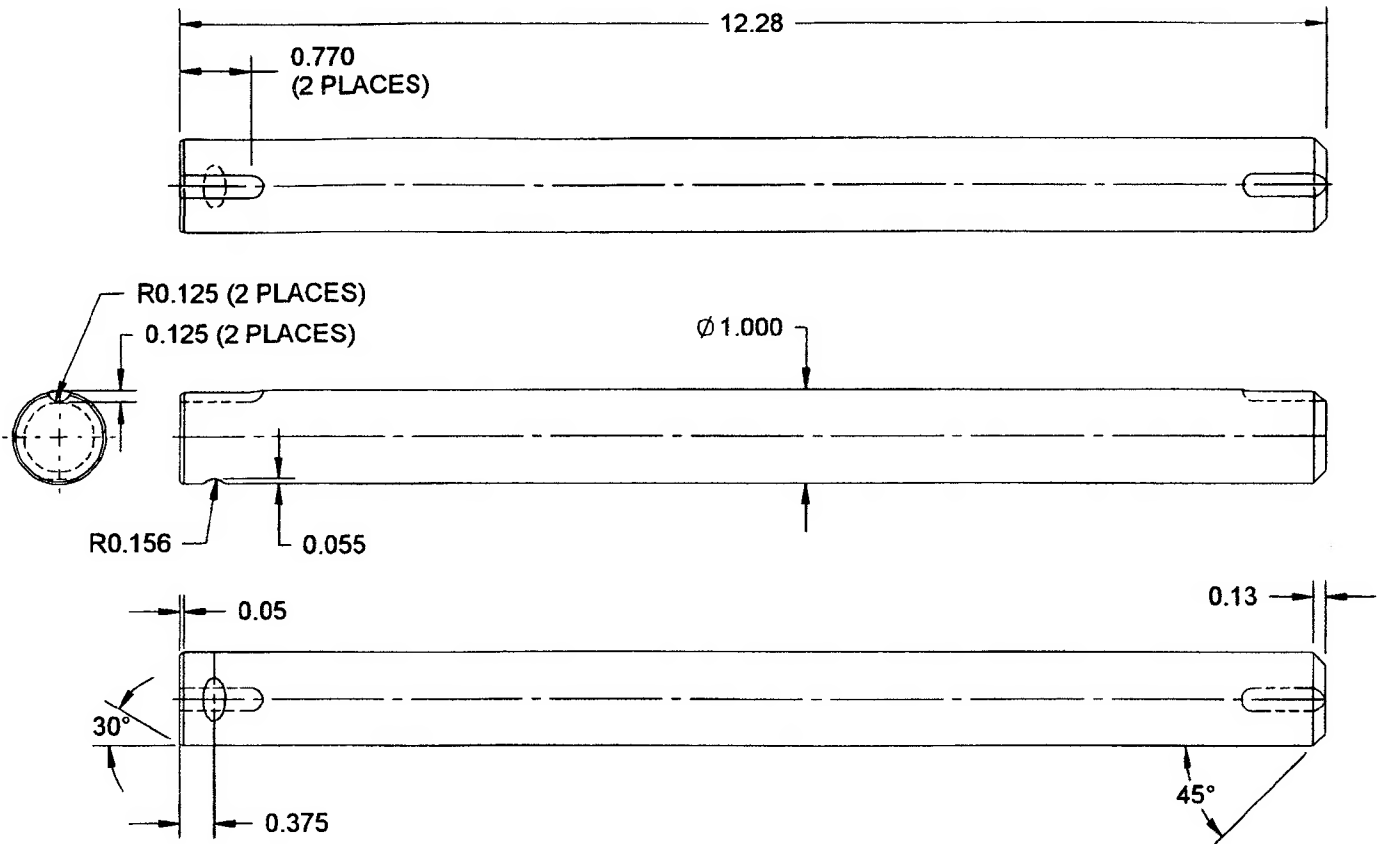
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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:2

RELEASED
W 07.02.02



D3354-1 INNER SHAFT

NOTES:

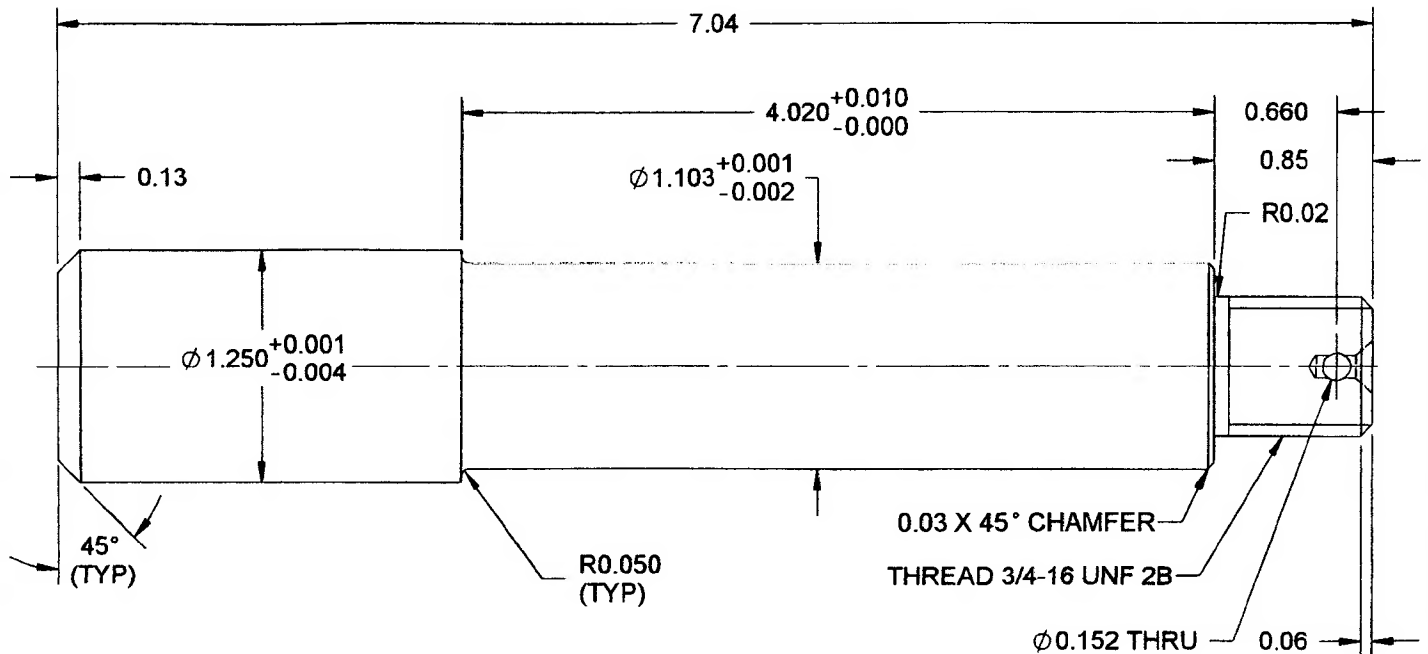
- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, $\varnothing 1.250$ (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:1

RELEASED
[Signature] 07.02.02**D3354-3 WHEEL SHAFT****NOTES:**

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

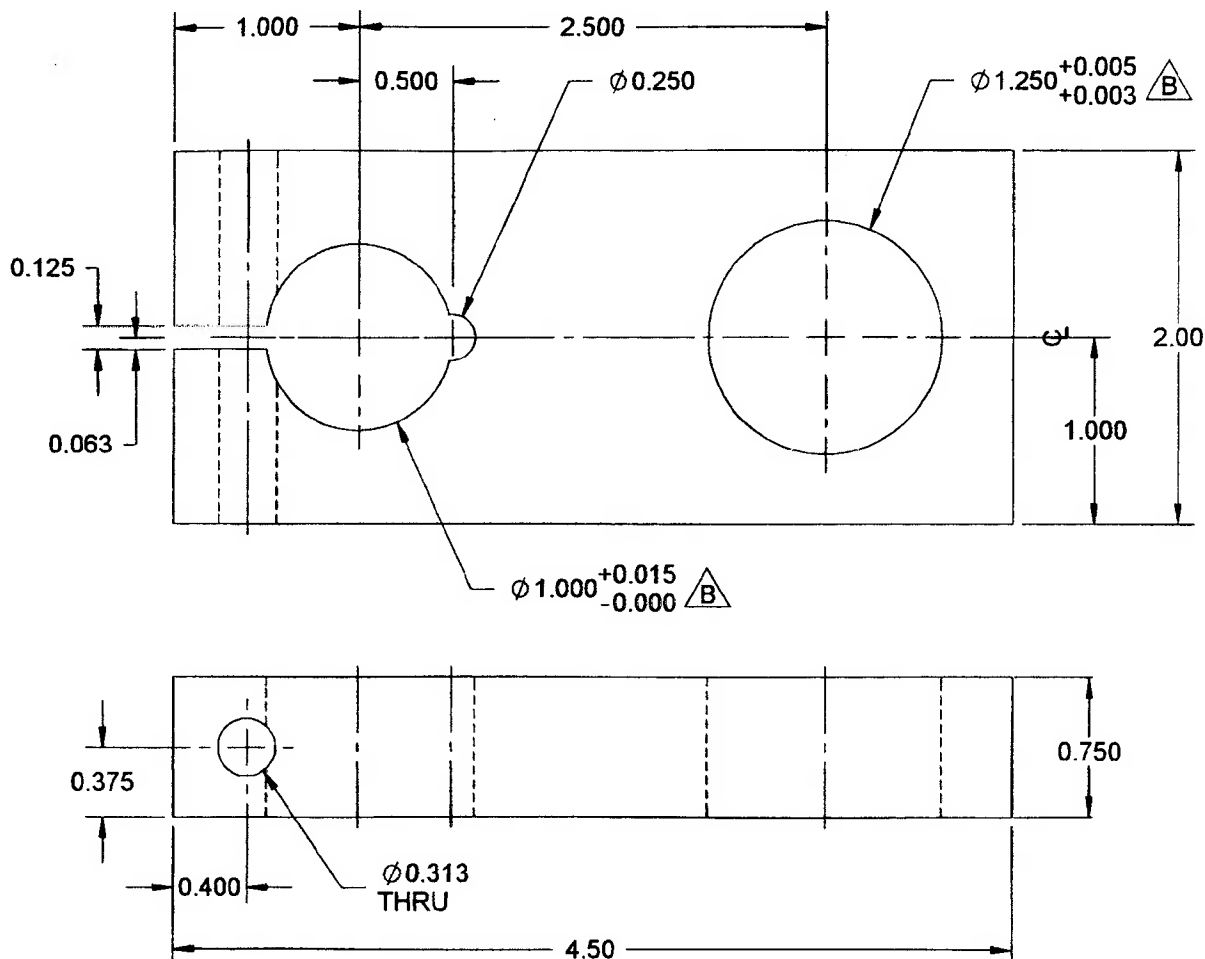
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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:1

RELEASED
R 07.02.02



D3354-5 RIGHT ARM PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

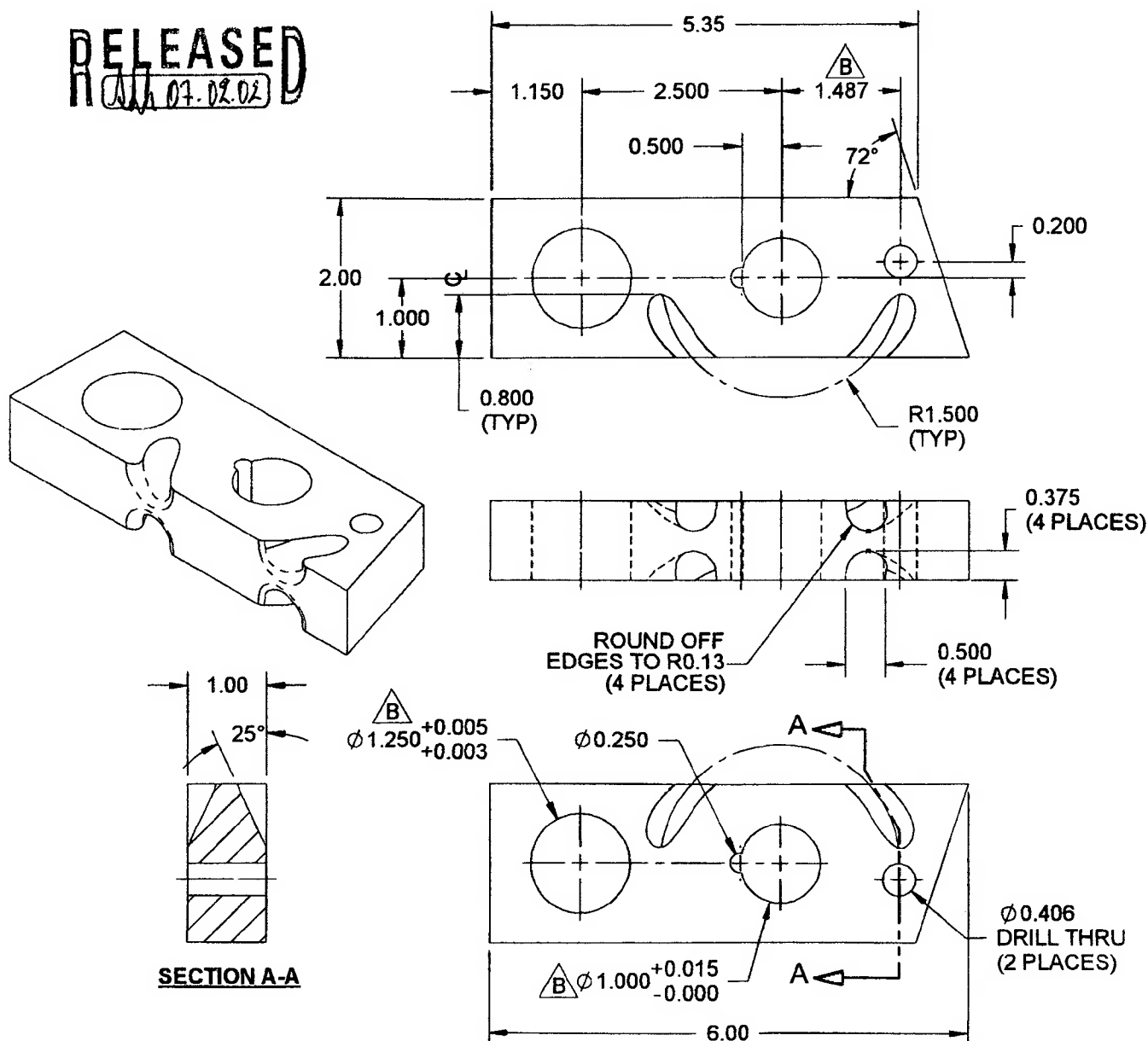
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DATE 07.02.02	TITLE LEFT ARM WELDMENT		SCALE 1:2

RELEASED
07.02.02



D3354-7 LEFT ARM PLATE

NOTES:

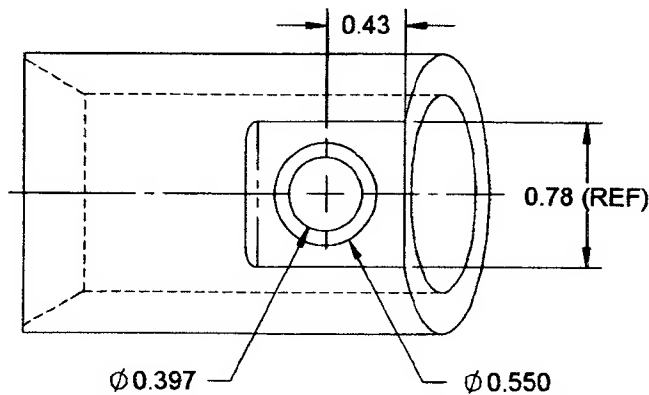
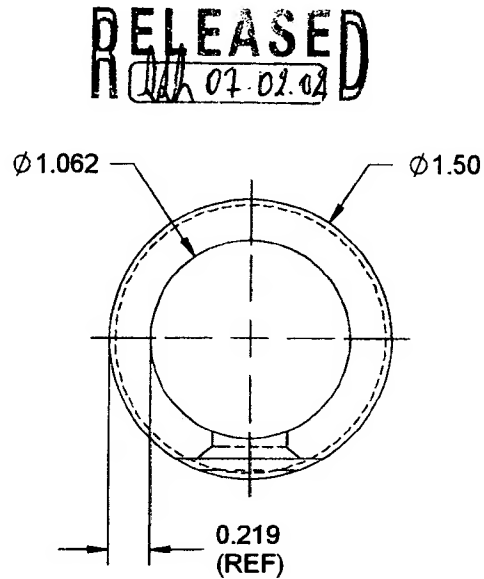
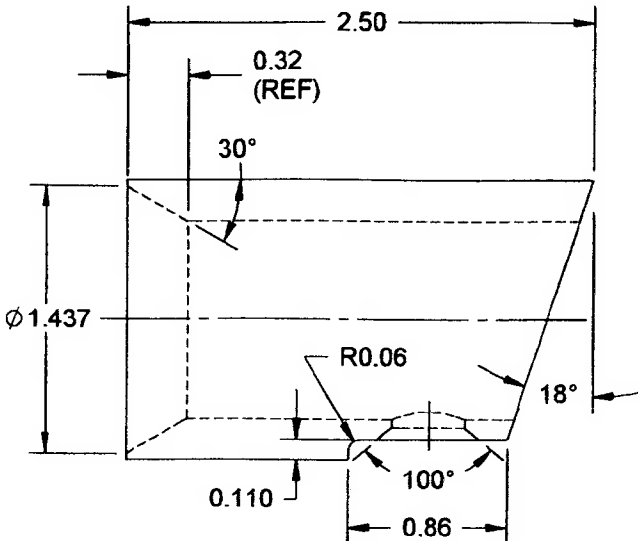
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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DATE 07.02.02		TITLE LEFT ARM WELDMENT	SCALE 1:1



D3354-9 HANDLE SOCKET

NOTES:

- 1) MATERIAL: AISI 1010-1025 SEAMLESS ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, (REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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